

Date: Wednesday, 12/11/2008 1:37:11 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: JACK
Job Number	: 43352 -1		
Estimate Number	: 10527		
P.O. Number	:	Part Number	: D33361
This Issue	: 12/11/2008 S.O. No. :	Drawing Number	: D3336 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 37786	Material	:
Written By	:	Due Date	: 28/11/2008
Checked & Approved By	: <u>JUD 08.11.12</u>	Qty:	<u>12</u> Um: Each
Comment	: Est. A05.01.13 New issue KJ/JLM		
	: Est. A05.12.13 Added paint EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 7576C208/11/13 (12)

For D3336-1 Jack P/N: 76508

Possible Supplier: Auto PartsProduct Specification sheet is required

2.0	76508	JACK
-----	-------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
 JACK

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure Product Specification sheet is attached

Pc 8/12/17 (12)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Drill base of jack using DT8761 as per Dwg D3336

2-Check ram length, then tack weld as per Dwg D3336

3-Drill and Tap ram as per Dwg D3336

SP 09.01.07 (12x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:37:11 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK

Job Number: 43352

Part Number: D33361

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Paint base cuts to match color per dwg D3336

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11/17/13

FZ 09/01/13

(10)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/13 (40)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57490 09/01/14 (W)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/15

Job Completion



MF 09-01-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

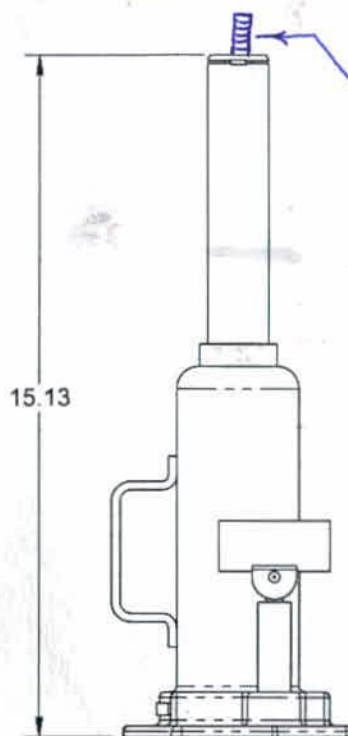
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3336	REV. A SHEET 1 OF 1
DATE 04.12.16		TITLE JACK	SCALE 1:2
A	04.12.16	NEW ISSUE	



DETAIL A: SIDE VIEW
SCALE 1:4

*CUT BOLT AND WELD
ON JACK*

1/4-20 BOLT

DRILL 0.201 x 1.00 DEEP
AND TAP 1/4-20 x 0.75 DEEP
AT CENTER OF CAP.

WELD CAP WITH SHAFT
WITH 0.375 LONG
TACKS (2 PLACES)
AROUND PERIMETER

RELEASED
[Signature]
05/02/09

DRILL 0.312 PER
TEMPLATE DT8761
(2 PLACES)

COUNTER BORE $\phi 0.38$
IF NECESSARY FOR
CLEARANCE OF BOLT
HEAD (2 PLACES)

TRIM EDGES AS PER
TEMPLATE DT8761
AND PAINT CUTS TO
MATCH COLOR.

D3336-1

NOTES:

- 1) MATERIAL: 8 TONS JACK. POSSIBLE SUPPLIER: AUTOPARTS
MODEL NUMBER 76508
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. *13352*

COPYRIGHT © 2004 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



**AUTO PARTS • PIÈCES D'AUTO
TRUCK PARTS • PIÈCES DE CAMION
ENGINE-MARINE • MOTEUR-MARINE
PERFORMANCE PARTS • PIÈCES DE PERFORMANCE
TIRES • PNEUS**



C-07070

Past due accounts bear 2% interest per month (24% per annum). If this account is placed with a 3rd party collection, an administrative cost of 25% will be added. All exchanges and refund claims must be accompanied by this invoice. Electrical parts not returnable. All parts returned are subject to 20% handling charge. All merchandise sold on this invoice remains the vendor's property until this invoice is paid in full.
TERMS: Payment due on 10th day of the following month.

Aucun remboursement sans cette facture. Net 30 jours, 2% de frais d'intérêt par mois (24% par année) sur compte en souffrance. 20% de frais de manutention sur toute marchandise retournée. Clause pénale une indemnité de 25% sera chargée sur compte sujet à des procédures légales. Les marchandises mentionnées sur cette facture demeurent la propriété du vendeur tant qu'elles ne seront pas entièrement payées. Pièces électriques non-retournable.
TERMES: Compte payable le 10 du mois suivant.

SIGNATURE _____

GST / TPS
10035 3366 RT0001

1000 RUE LANDSDOWNE HAWKESBURY, ON K6A 1H7
TEL: (613)632-1191 FAX: (613)632-2350

TVQ
1016330716 TQ0001

A TOUS NOS CLIENTS, NOUS VOUS SOUHAITONS UN JOYEUX NOEL ET UNE MERVEILLEUSE ANNEE
TO ALL OUR CUSTOMERS, WE WISH YOU A MERRY CHRISTMAS AND A WONDERFUL YEAR


113336 (613)632-5200
S V DART AEROSPACE LTD.
O E N 1270 ABERDEEN STREET
L D D U
T O A HAWKESBURY ON K6A 1K7

EXP
SHIP
PIE
TER
TO
A

113336
*** SAME ***

DATE: 12/16/08
13:00
11C MLP

PO
00007571

ORD / COM	SHIP / EXP	CODE	PART No / PIÈCES	DESCRIPTION	LIST EACH / CHACUN	COST / COÛTANT	EXTENSION		
12	12	G2S>	NOR76508 ✓ DE G2S # IN154755	BOTTLE JACK		134.00	1608.00		
	12	***	SHIP VIA	PIECES / CORE TOT REGULAR	0.00		0.00		
									
INVOICE No / FACTURE		TYPE / SORTIE		TOTAL	DISC / ESC	FRT / TRANS	GST / TPS	PST / TVQ	AMT TO PAY / À PAYER
11917298		INVOICE		1608.00	0.00	0.00	80.40	0.00	1688.40

VERSUS BUSINESS FORMS (CORNWALL) (613) 936-1852